

Date: Thursday, 12/13/2007 11:21:11 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY- UNDER REVIEW
Job Number : 36299	
Estimate Number : 11067	
P.O. Number :	Part Number : D2950041
This Issue : 12/13/2007 S.O. No. :	Drawing Number : D2950 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1 UNDER REVIEW <i>OK 12/13</i>
Previous Run : 28266	Material :
Written By :	Due Date : 12/21/2007 Qty: 10 Um: Each
Checked & Approved By : <i>12/13</i>	<i>8</i>
Comment : Est C 02.04.27 Added D3161-3 & dwg Rev.A1 (MPP 2241) N G	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31613	Hinge 15.0"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~20.0000~~ Each(s) *16*

Pick: Assembly Kit

✓	Qty Part Number	Description	Batch
	2 D3161-3	Hinge	<i>B34028 X11</i> <i>B36334 X5</i>

ml 08/01/04

2.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 24.0000 Each(s)/Unit Total : ~~240.0000~~ Each(s) *192*

Pick: Assembly Kit

✓	Qty Part Number	Description	Batch
	24 MS20470AD4-4	Rivet	<i>M105108</i>

ml 08/01/04

3.0	D29501	Door Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)

Door Assembly

Pick:

✓	Qty	Part Number	Description	Batch
	1	D2950-1	Door	<i>B17371 X8</i>

ml 08/01/04

4.0	D29503	Door Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)

Door Assembly

Pick:

✓	Qty	Part Number	Description	Batch
	1	D2950-3	Door	<i>B17372 X8</i>

ml 08/01/04

W/O:		WORK ORDER-CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2950

x8 PTO

ml 08/01/04

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/04 (18)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

IBR 08-01-11

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H 08/01/11 (8X)

9.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number

Description

Batch

1

MS20470AD4-6

Rivet

M106375

AS 08/01/14

(X18)

10.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

1

AN960JD6

Washer

M10085

AS 08/01/14

(X18)

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Handle

Pick:

Qty Part Number

Description

Batch

1

D2419

Handle

36228

AS 08/01/14

(X18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2950-041 PAR #: N/A Fault Category: Prod-Sm FAB NCR: Yes No DQA: A Date: 08.01.21
 QA: N/C Closed: JA Date: 08.01.22

NCR: <u>36299</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/14	5	Hinge move when drilling	<i>[Signature]</i>	Scrap 2 hinges D 3161-3 Replace by new one B# <u>B36334</u>	<i>[Signature]</i> 07/12/14	<i>[Signature]</i> 08/01/14	<i>[Signature]</i> 08/01/14	<i>[Signature]</i> 08/01/14

NOTE: Date & initial all entries

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Process Sheet

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Job Number: 36299

Part Number: D2950041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch

1 D2137 Decal 36227

AS 08/01/14 (x8)

13.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal 24215

AS 08/01/14 (x8)

14.0

D24620039

Seal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

2 D2462-0039 Seal B 29456 5.2

AS 08/01/14 (x8)

15.0

D24620220

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0220 Seal B 29456 1.83

AR 08/01/14 (x8)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2950

Note: Ensure decals are firmly attached to panel

ml 08/01/16 (x8)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/16 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2950041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 214

AS 08/01/18

(Y8)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08.01.21

Job Completion



mi 2008.1.14

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



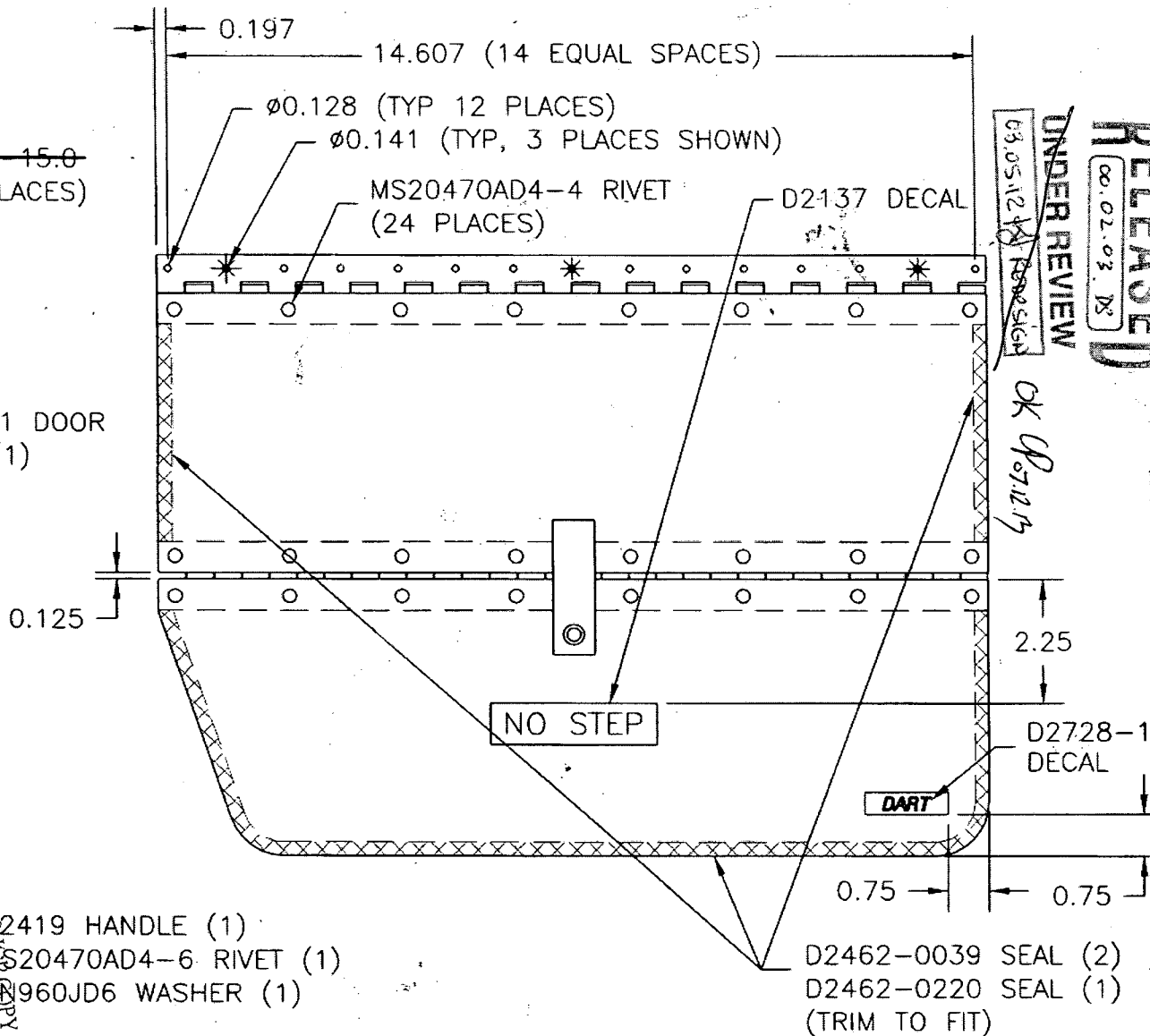
RELEASED
00.02.03 DS

UNDER REVIEW

03.05.12 18 180516H

OK 07.12.17

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CP	CP	
CHECKED	APPROVED	DRAWING NO.
CP	CP	D2950
DATE	TITLE	SCALE
00.01.20	DOOR ASSEMBLY	1:3
A	00.01.20	NEW ISSUE
A1	02.04.24	D3161-3 REPLACES MS20257-3-15.0

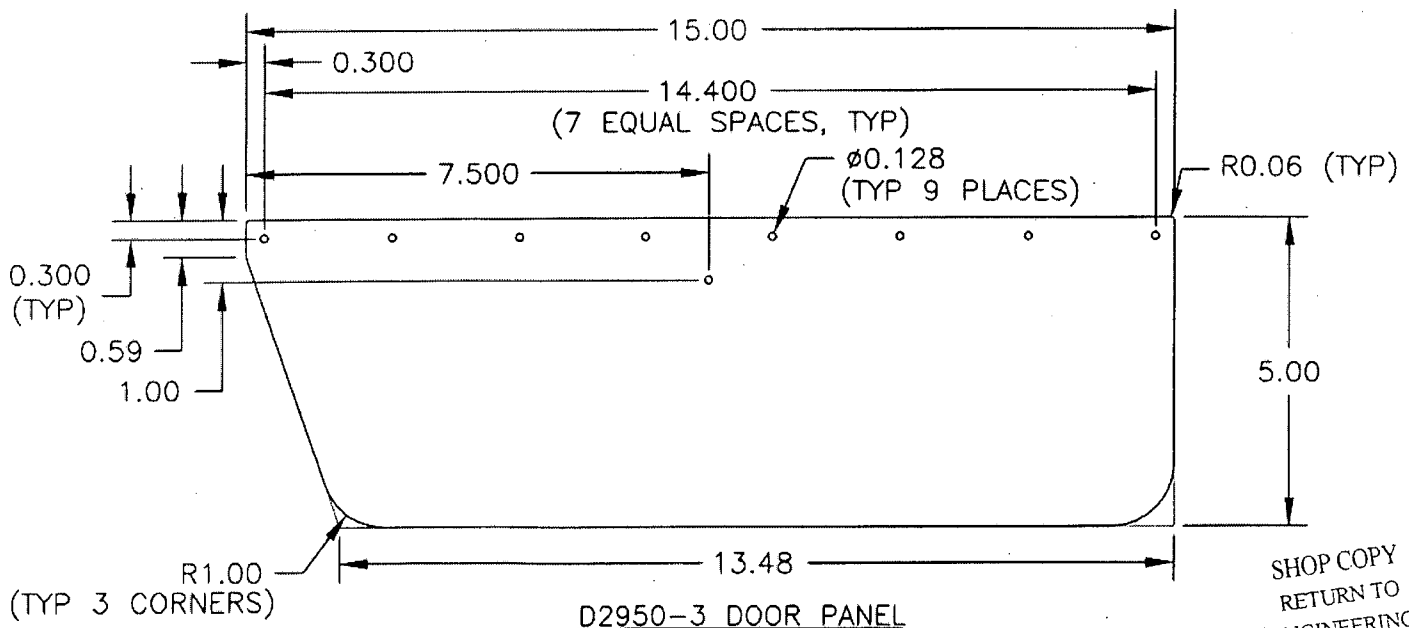
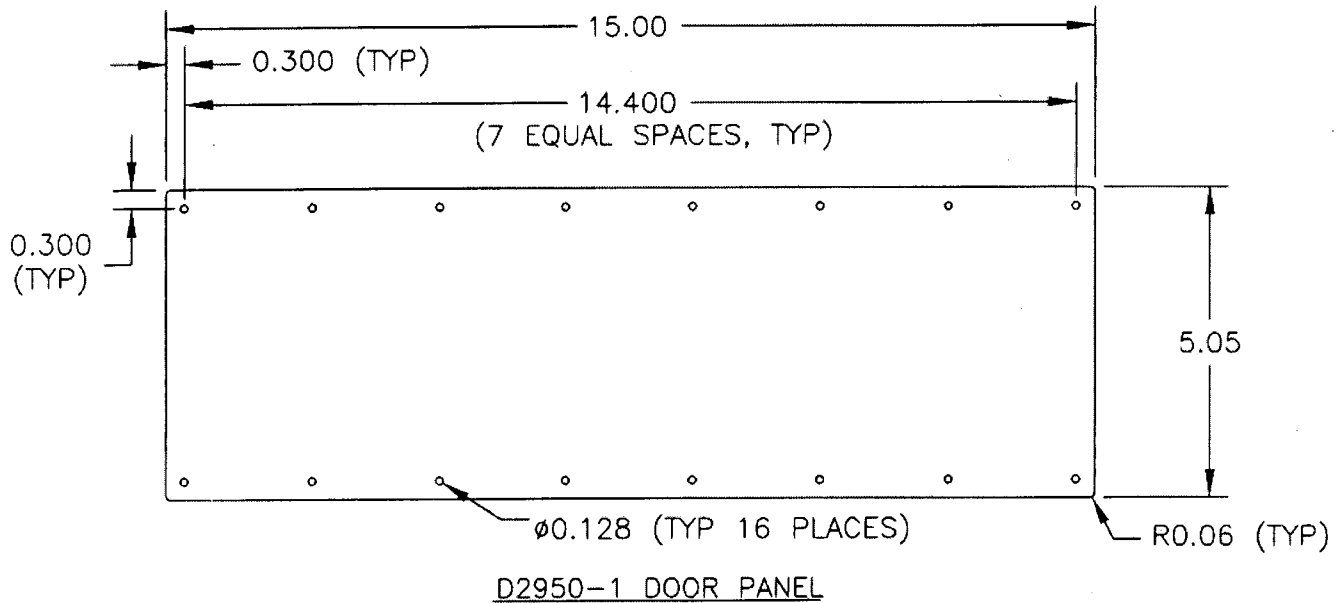


UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
362299

D2950-041 DOOR ASSEMBLY
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2950	REV. A SHEET 2 OF 2
DATE 00.01.20		TITLE DOOR ASSEMBLY	SCALE 1:3



D2950-1 AND D2950-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
00.02.03
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36299